

Date: Wednesday, 06/08/2008 2:06:49 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ARM
Job Number	: 41030		
Estimate Number	: 11669		
P.O. Number	:	Part Number	: D2846
This Issue	: 06/08/2008 S.O. No. :	Drawing Number	: D2846 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 33593	Material	:
Written By	:	Due Date	: 20/08/2008
Checked & Approved By	: <u>JP 08.8.06</u>	Qty:	12 Um: Each
Comment	: Est. F 02.02.12 Added Inspection Level 8 and Level 5 SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6102005	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Billet 1X15.25X48" Pick Billet: D6102-005 (15.25" x 48.00" x 1.00") Note: 1 Billet makes 3 parts Batch No: <u>B 41961</u> <u>ML 08/10/17</u> (12)		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio FA194 - Deburr <u>ML 08/10/17</u> (12)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ML 08/10/17</u> (12)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SS 08/10/18</u> (12)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill holes as per Dwg D2846 and Drill Jig DT8249 <u>FF 08/10/23</u> (12)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:50 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ARM

Job Number: 41030

Part Number: D2846

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (412)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h 08/10/27

(12X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:20

OVEN TEMPERATURE:

320°

FINISH TIME:

8:50

FX 08/10/28

(12)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-28 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 203 new location

08/10/28 (12)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

(12)

Job Completion



08/10/29

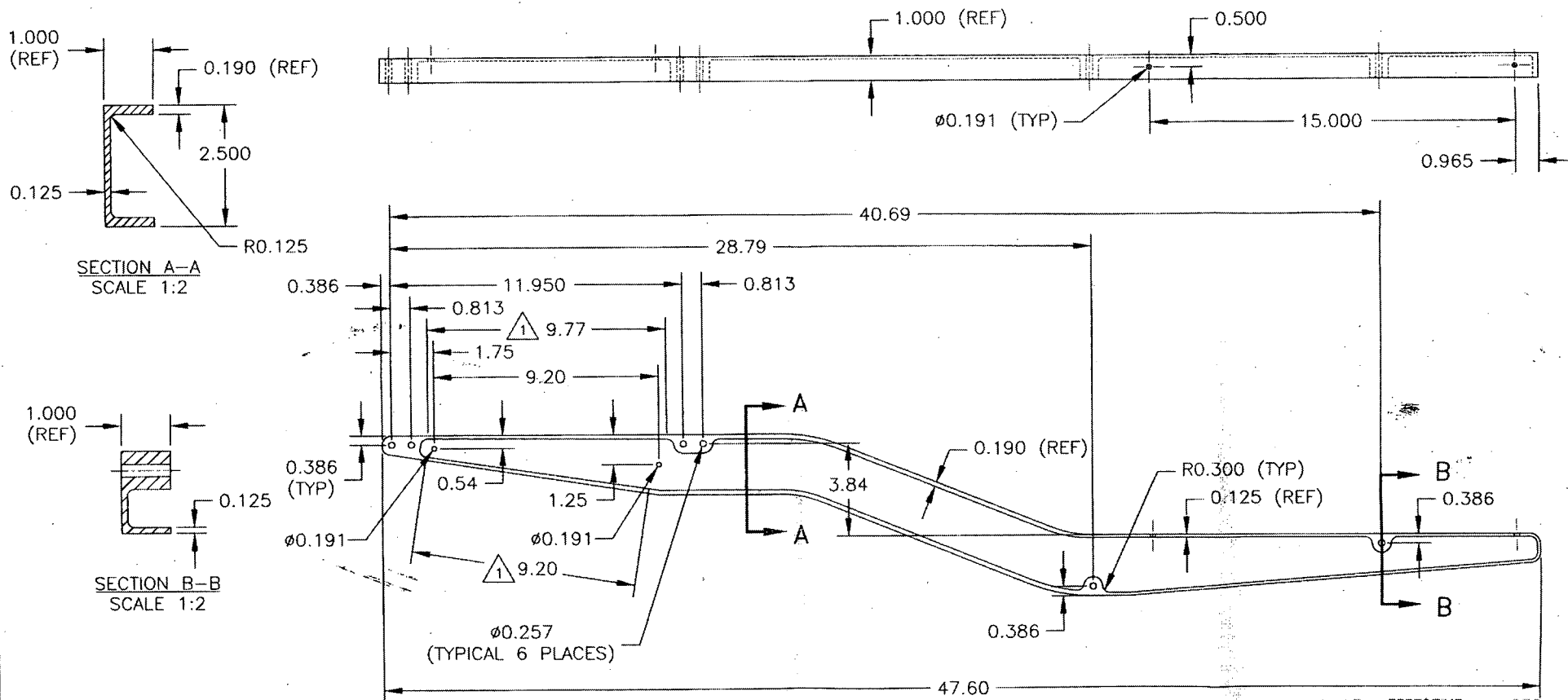
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) VE 98.12.03 T52 A103
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1 TAPERED WALL THICKNESS FROM 0.190" TO 0.125" OVER INDICATED LENGTH

RELEASED 98.11.19 KE
 EFFECTIVE 9126
 DEC 9

A	98.11.04	NEW ISSUE	
DESIGN KE	DRAWN BY KE	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. A
CHECKED RA	APPROVED	DRAWING NO. D2846	SHEET 1 OF 1
DATE 98.11.04		TITLE SUPPORT ARM	SCALE 1:4

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 WORK ORDER
 NO. 11030



